

SPLIT

Dart Aerospace Ltd.

Date: Monday, 10/11/2008 10:43:50 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TOW RING
Job Number : 43274	
Estimate Number : 13456	
P.O. Number :	Part Number : D3407045
This Issue : 10/11/2008 S.O. No. :	Drawing Number : D3407
Prsht Rev. : NC	Project Number : N/A
First Issue : / /	Drawing Revision :
Previous Run : 42438	Material :
Written By :	Due Date : 21/11/2008
Checked & Approved By : JUD 08.11.10	Qty: 30 Um: Each
Comment : Est Rev:A New Issue 08-07-09 JLM Verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D34075	Ring
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3407-5 Ring B43344		
2.0	D34077	TOW RING
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) TOW RING B43834		
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 Weld D3407-5 and D3803-1 using welding rod TIG174 as per Dwg D3803 & QSI 004 A/R TIG174 ROD Batch: M101972		
4.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION		
5.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/11/2008 10:43:50 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW RING

Job Number: 43274

Part Number: D3407045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M109152



(16x)

Comment: POWDER COATING

✓ Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
Mask Threaded Section

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:40
400 °F
1:10

m-f

08/12/09

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-12-09

(X16)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST464

8/12/10

(16)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/11 JS

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-10

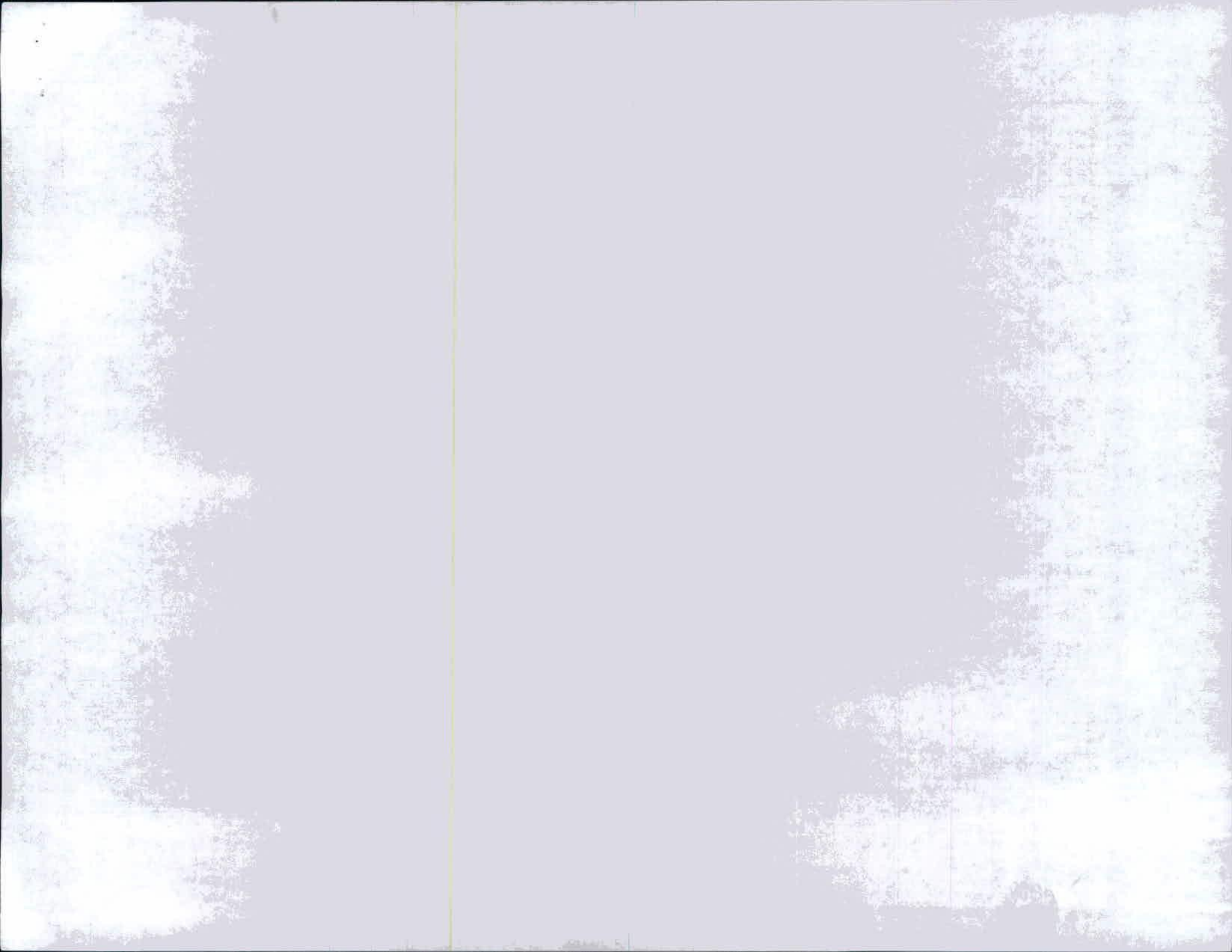
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

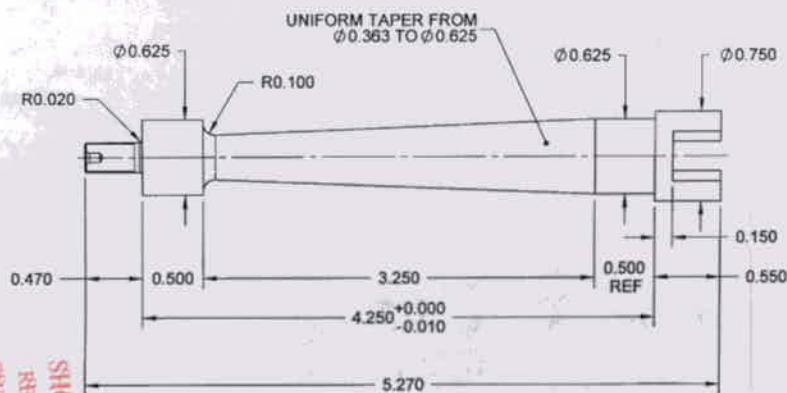
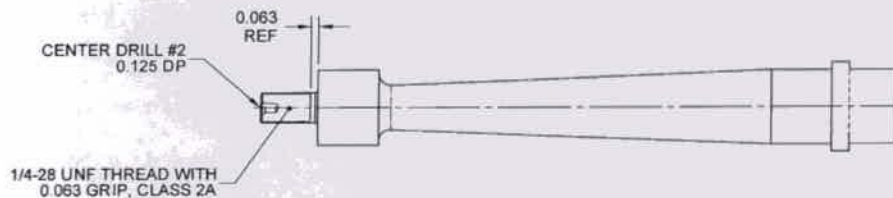
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

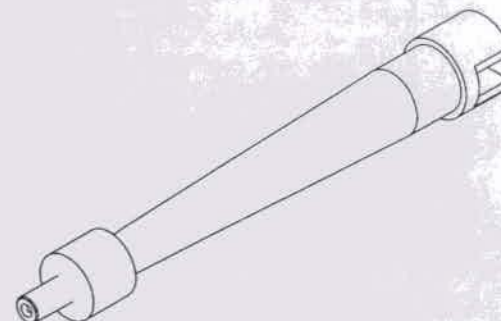
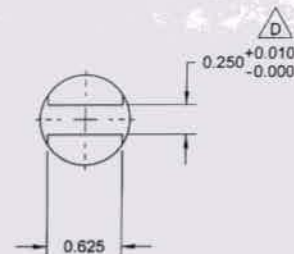
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





D3407-1 STEM



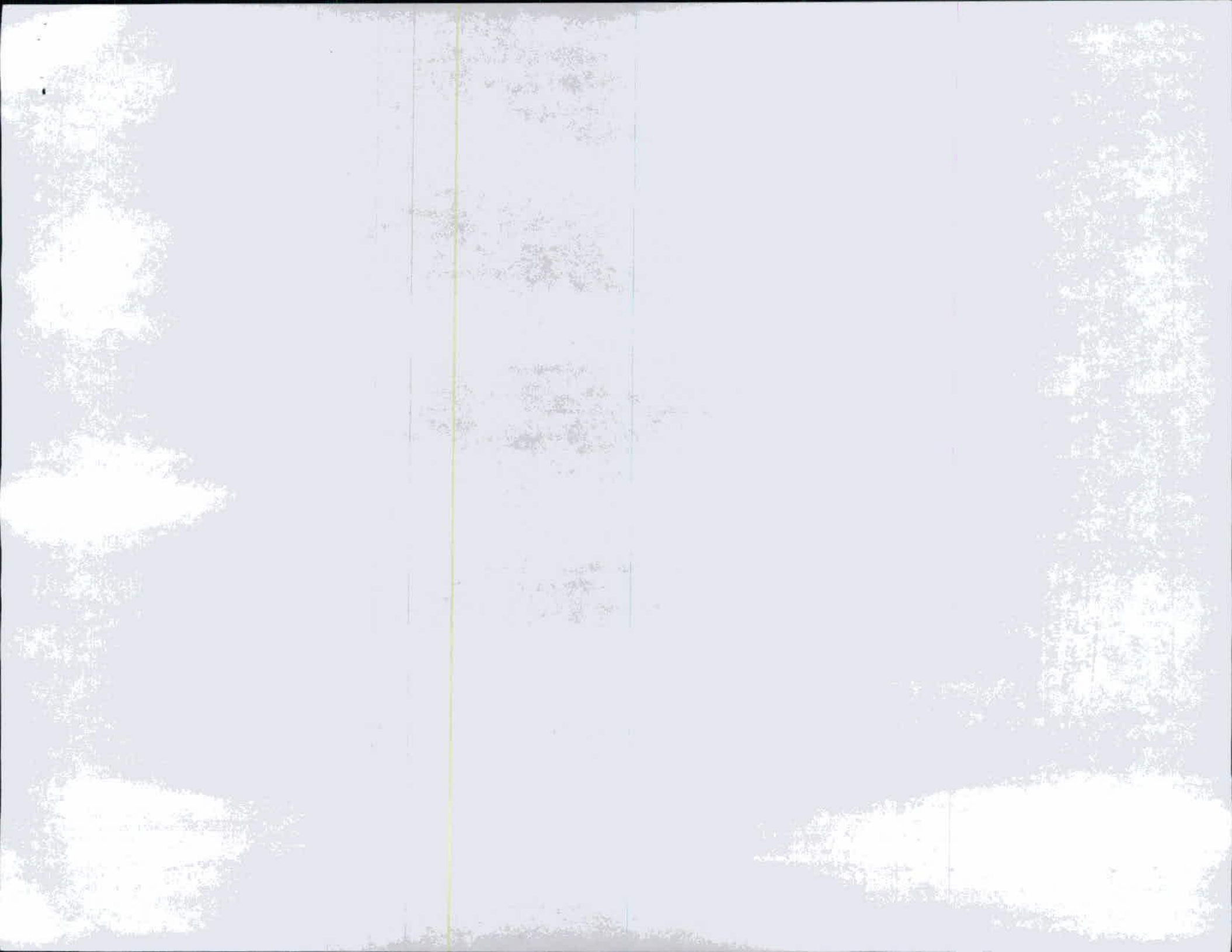
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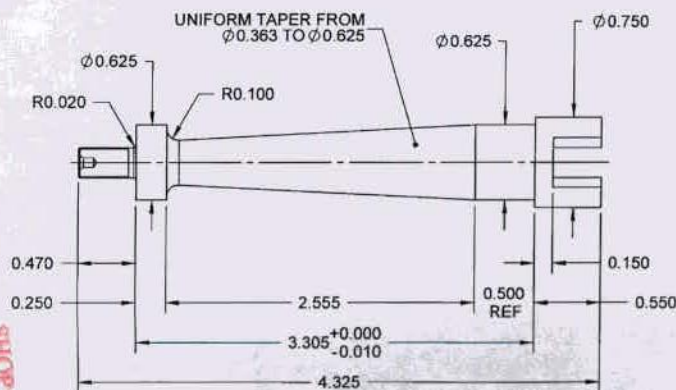
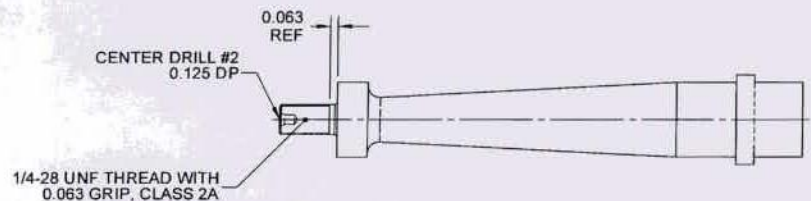
- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.33 lbs

RELEASED
 08-07-23

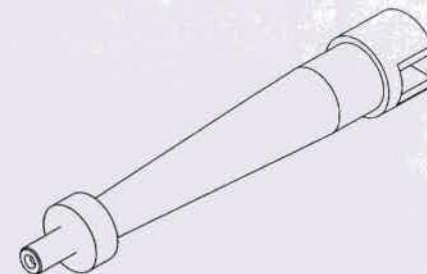
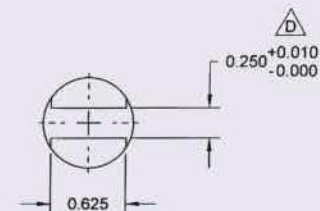
DESIGN		DART AEROSPACE USA, INC.
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. D3407
MFG. APPR.		REV. E
APPROVED		TITLE TOW RING
DE APPR.		SCALE NTS
DATE	08.07.23	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.

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D3407-3 STEM

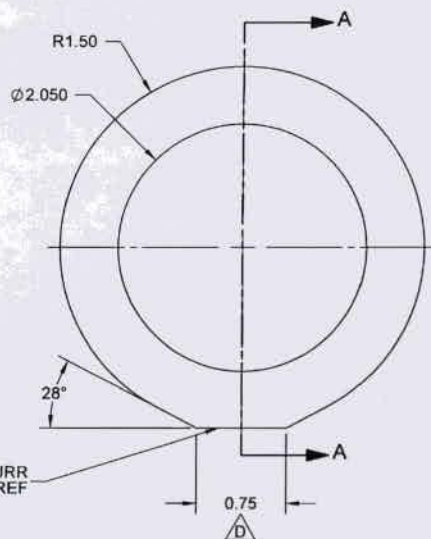


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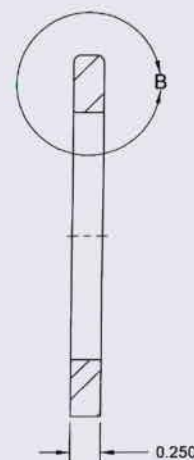
- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

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08-07-23

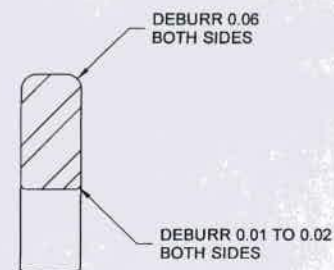
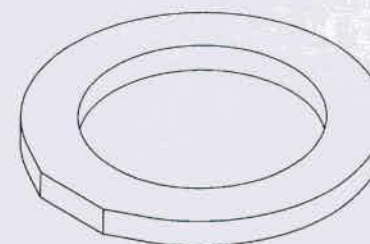
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CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 3 OF 5
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DE APPR.		TOW RING	NTS
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D3407-5 RING



SECTION A-A



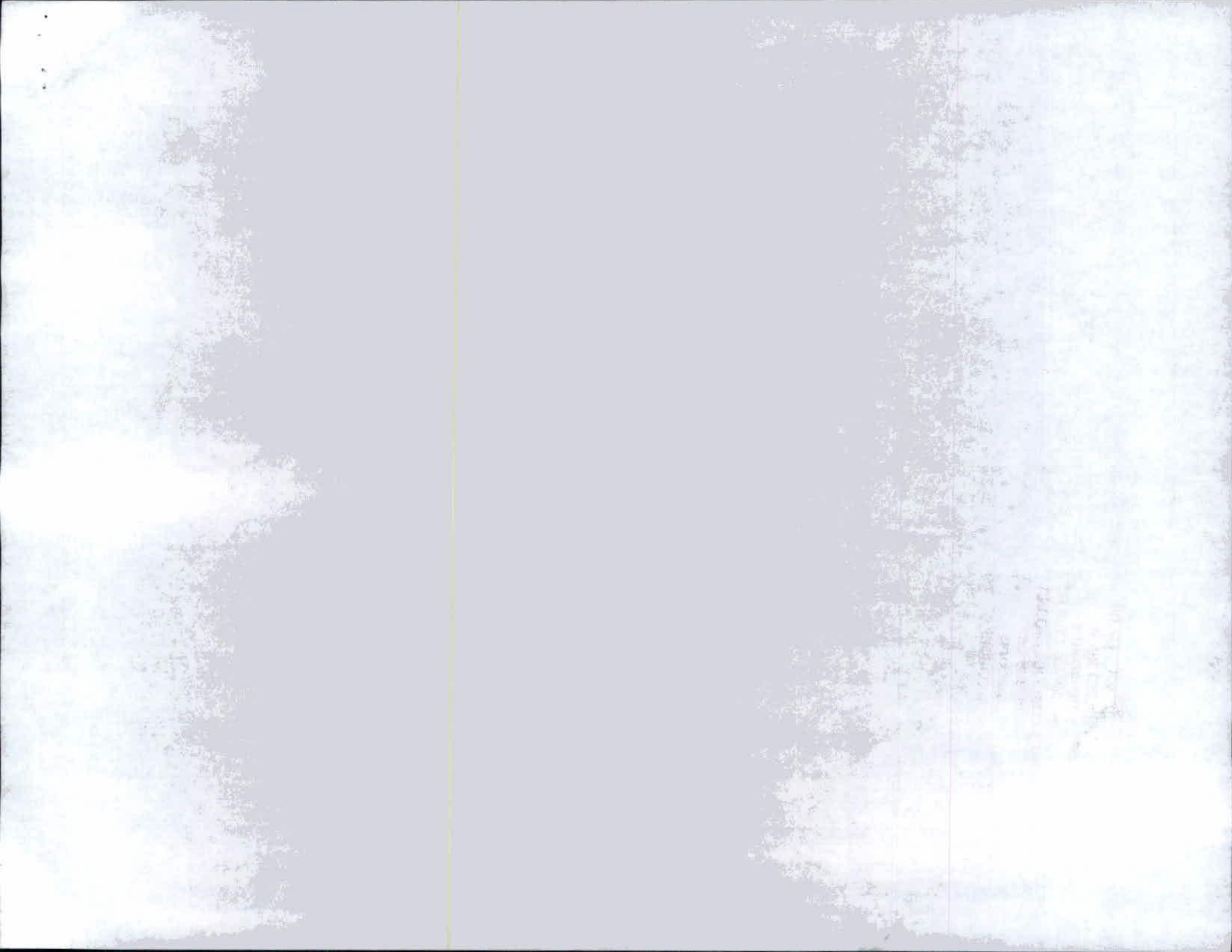
**DETAIL B
SCALE 2X**

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08-06-01/10

- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

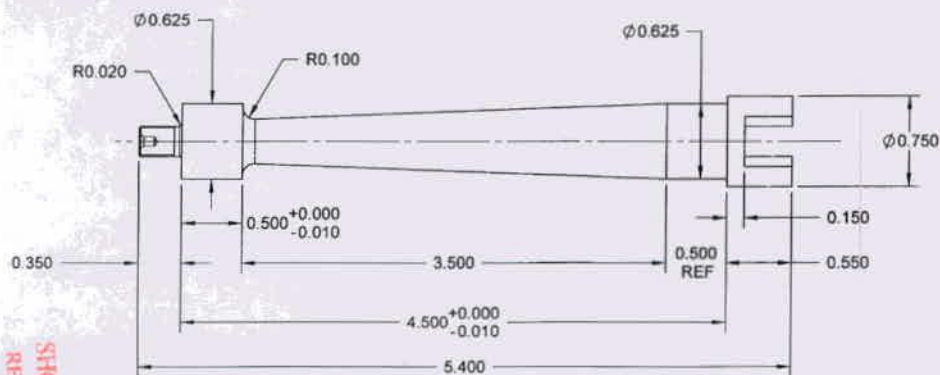
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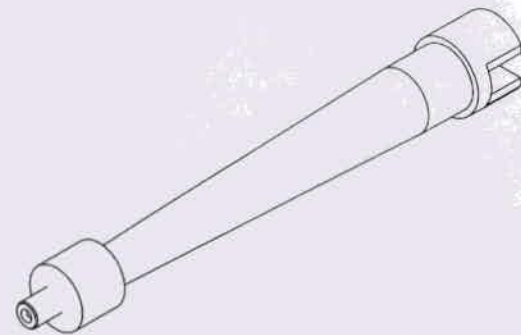
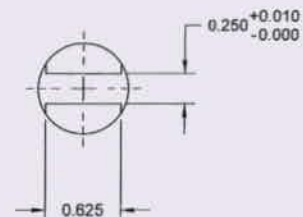




1/4-28 UNF THREAD WITH
0.063 GRIP, CLASS 2A



D3407-7 STEM



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- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.34 lbs

RELEASED
08-07-23

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MFG. APPR.		TITLE	SHEET 5 OF 5
APPROVED		TOW RING	SCALE
DE APPR.			NTS
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